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D3075-1

Job Sheet 215046



Part No: D3075-1

Job Qty: 12 pcs

DAS
21
9-89

Part Name: Bearpaw (Foot Print Only)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/20

Job Tracking No:

Due Date: 11/20/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM IPP Rev:D Added C'Bores as per Rev B 07-03-28 JLM IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC IPP Rev:F 08-11-12 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	12 pcs	11/19/20		0.17	1.96	Waterjet - Flow		20/11/12
120	HAAS 4 Axis - B4B	12 pcs	11/20/20		1.00	3.00	HAAS - 1 - B4B		
							HAAS - 2 - B4B		ALA
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 8	12 pcs	11/20/20		0.00	0.00	QC 8 - 12		20/11/22
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		

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				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
150	Packaging 3-1 - Stock - B4B 12 pcs	11/20/20	0.00 0.00	Packaging 3 - 1 - B4B	
	13 Pcs ✓			Packaging 3 - 2 - B4B	DAS
				Packaging 3 - 3 - B4B ✓	NOV 2 4 2020 80
				Packaging 3 - 4 - B4B	ST452 9-89
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
160	QC 21 - SA 12 pcs	11/20/20	0.00 0.00	QC 21 - SA - 21	28
	13 pcs mtd			QC 21 - SA - 70	9-89
				QC 21 - SA - 9	
				QC 21 - SA - 77	NOV 2 4 2020
				QC 21 - SA - 28	

Part Op 110 - CUT BLANK AS PER FILE D3075-1_BLANK
 Descriptions: 120 - HAAS CNC Vertical Machine - Note: (2) Bearpaw for (1) Kit 2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1
 140 - QC8- Inspect parts - second check
 150 - Identify as per dwg & Stock Location: _____
 160 - Identify as per dwg & Stock Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	12 sf (1 ea)	10 Waterjet - Flow - 1	5228711
		1.4 ea 9-89		5235828

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Waterjet - Flow - 1	MUHMWB10	12	434	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	R44 Bearpaw	0.070inches + 0.030 - 0.010	0.100 0.060	.070"	
2	R44 Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45°	
3	R44 Bearpaw	0.630Degrees ± 0.030	0.660 0.600	.640"	
4	R44 Bearpaw	0.250inches ± 0.010	0.260 0.240	.258"	
5	R44 Bearpaw	0.950inches + 0.030 - 0.010	0.980 0.940	.960"	
6	R44 Bearpaw	5.500inches ± 0.030	5.530 5.470	5.502"	
7	R44 Bearpaw	0.250inches ± 0.030	0.280 0.220	.255"	
8	R44 Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45°	
9	R44 Bearpaw	0.900inches ± 0.010	0.910 0.890	.900"	
10	R44 Bearpaw	0.375inches ± 0.010	0.385 0.365	.381"	
11	R44 Bearpaw	1.300inches ± 0.030	1.330 1.270	1.280"	
12	R44 Bearpaw	5.700inches ± 0.030	5.730 5.670	5.695"	
13	R44 Bearpaw	0.370inches ± 0.030	0.400 0.340	.380"	
14	R44 Bearpaw	3.600inches ± 0.010	3.610 3.590	3.602"	
15	R44 Bearpaw	0.260inches + 0.005 - 0.000	0.265 0.260	.260"	
16	R44 Bearpaw	0.930inches ± 0.030	0.960 0.900	.930"	
17	R44 Bearpaw	0.300inches + 0.030 - 0.000	0.330 0.300	.307"	
18	R44 Bearpaw	1.080inches ± 0.030	1.110 1.050	1.076"	
19	R44 Bearpaw	5.870inches ± 0.010	5.880 5.860	5.869"	
20	R44 Bearpaw	10.140inches ± 0.030	10.170 10.110	10.142"	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S312568



Part: D3075-1

Job No: 215046

Serial No/Batch: S312568

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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